

Work Order ID 76667

76667

Page 1

November-18-11 1:03:05 PM

Item ID: D350-636-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Skidtube LH

Start Date: 18/11/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 02/12/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: M.L.J

Date: 11/11/18 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2750	F								
D3492	C								

100

100

DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy blue file and type labels per PPP D350-636-011 CHG 006

0.00

0.00

8/11/22

for M.L.J 11-12-22

①

7999L

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 76667

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76667

Page 2

Item ID: D350-636-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube LH

Start Date: 18/11/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 02/12/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

0.00

110

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.

4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting

5- Drill only two fwd step holes using DT9616. Ensure proper positioning.

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail B)

7- Clecko DT8863B on second side of tube and drill pilot holes for detail B.
SECOND SIDE

8-Open up holes for Detail B to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up holes for ground handling and detail C to 0.500" (8 holes per side)

9-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

10-Open up holes of Detail A to 0.297" (total of 2 holes per side)

MO

11-11-25

B 11/12/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Item ID: D350-636-011

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N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube LH

Start Date: 18/11/2011 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 02/12/2011 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QS1005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									
150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.00							
Quality Control									

① 3A0 11-12-05

DP 11-12-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID 76667***76667***

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube LH

Start Date: 18/11/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 02/12/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

0.00

160

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Open up holes of Detail C and ground handling to 0.625" (total of 8 holes per side)
as per dwg D2750.2-Open up holes of Detail B to 0.750" (total of 4 holes per side)
as per dwg D2750.

3- Open float hole to 0.500" (4 per side)

4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750
(welding instructions on sheet 8)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI015

A/R Sikaflex-291

batch: 117399exp. date: 12/08/138- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004
(welding instructions on sheet 8)

A/R Aluminum Rod

batch: M118735

9- At section AJ-AJ drill out x-bolt spacer to 0.404"

10-Grind welds flush as per Dwg D2750

SAD
11-12-05BE 11-12-06
11/12/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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November-18-11 1:03:05 PM

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N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube LH

Start Date: 18/11/2011 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 02/12/2011 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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11-Spot face ground handling holes section (total of 4 places per side) as per
dwg D2750

12-Deburr holes

170

QC10- Inspect visual per QSI004- ground welds 0.00

170

QC

Memo

0.00

Quality Control

180

QC5- Inspect part completeness to step on W/O 0.00

180

QC

Memo

0.00

Quality Control

Handwritten signature and date 11/12/06

Handwritten date 5/12/07

Handwritten date 5/12/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 76667

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Item ID: D350-636-011 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Skidtube LH
 Start Date: 18/11/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 02/12/2011 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Pressure Wash per QSI005 4.3	0.00							
190									
HandFinish	Memo	0.00							
Hand Finishing	Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.								<i>1X ✓ M- 11/12/10</i>
200	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
200									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: <i>9:30</i> OVEN TEMPERATURE: <i>320 OF</i> FINISH TIME: <i>10:00</i>								<i>1X ✓ M- 11/12/12</i>
210	QC3- Inspect Part Finish	0.00							
210									
QC	Memo	0.00							
Quality Control	Inspect for foreign object per QSI 024								<i>1 BR 11-12-21</i>

M 119480

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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November-18-11 1:03:05 PM

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Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube LH

Start Date: 18/11/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 02/12/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

220

0.00

220

HandFinishing

HandFinish

Memo

0.00

Hand Finishing

1- Install inserts as per Dwg D2750

1 BR 11-17-22

230

0.00

230

HandFinishing

HandFinish

Memo

0.00

Hand Finishing

1-Inspect for Foreign Objects

2-Spray inside of tube with "LPS-3" batch: W/A.

3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: 119443EXP DATE: 12-1

4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube

A/R 55-o'ring lube batch: 1103495-Coat all exposed fasteners with "LPS Procyon" batch: 114596

1 BR 11-17-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 76667***76667***

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Item ID: D350-636-011

Accept

N9000040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube LH

Start Date: 18/11/2011 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 02/12/2011 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

240

QC5- Inspect part completeness to step on W/O

0.00

240

QC

Memo

0.00

Quality Control

8/11/12/22

250

Pick Kit

0.00

250

Packaging

Memo

0.00

Packaging

11/12/22

260

QC4- 100% Inspect kits for completeness

0.00

260

QC

Memo

0.00

Quality Control

*****ensure antiseize is on AN8C21A bolts*****

8/11/12/22

180

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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November-18-11 1:03:05 PM

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N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube LH

Start Date: 18/11/2011 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 02/12/2011 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270		0.00							
270	Packaging								
Packaging	Memo	0.00							
Packaging	Package as per PPP D350-636-011								
280		0.00							
280	QC21- Final Inspection - Work Order Release								
QC	Memo	0.00							
Quality Control									

[Handwritten signature]

11/12/2011 *[Handwritten signature]*

[Handwritten signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

November-18-11 1:03:09 PM

Page 1

Work Order ID: 76667

76667

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 18/11/2011

Required Date: 02/12/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:I 02.09.25 Rearranged procedure steps KJ
 IPP Rev:J 06-03-23 As per Rev D JLM
 IPP Rev:K 06-07.13 As per dsi9343 EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verf:EC
 IPP Rev:M 08-04-22 update steps 4, 13 DD verified by:ec
 IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec
 IPP Rev:O 09-02-06 apply antiseize on AN8C21A bolts as per PAR09-010
 DD verf:EC IPP Rev:P 10.06.22 revise
 seq110 DD verf:EC IPP Rev:Q 10.10.01 as per IIN revH
 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3492-1		Manufactured	No			230	Each	54.0000	8	8			
D3492-1									**	8.		BR 11-12-22	
Plug													

* D3492 041

Location	Loc Qty	Loc Code
FP	54	
69531	8	
74444	46	

D3492-3		Manufactured	No			230	Each	97.0000	8	8			
D3492-3									**			BR 11-12-22	
Plug													

Location	Loc Qty	Loc Code
FP	53	
74447	53	
FP-B	44	
74871 ✓	44	

8.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 18/11/2011

Required Date: 02/12/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased

No

230

Each

251.0000

8

8

NAS1611-010

O-RING

**

BR 11-12-22

Location

Loc Qty

Loc Code

FP

251

110915

14

117460

8

118077

1

118612

3

119307

7

119438

168

119623 ✓

50

NAS1149D0863J

Purchased

No

250

Each

208.0000

2

2

NAS1149D0863.I

WASHER

**

Location

Loc Qty

Loc Code

ST298

208

118078

108

119307

100

D2744

Manufactured

No

110

Each

54.0000

1

1

D2744

Cap

**

BE 11-12-04

Location

Loc Qty

Loc Code

LG002

13

62715

1

70881

12

WA

41

71861

41

W/O:		WORK ORDER CHANGES					
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Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 18/11/2011

Required Date: 02/12/2011

Start Qty: 1.00

Required Qty: 1.00

D2600-3-BENT

Manufactured No

D2600-3-BENT

Extrusion Bent

110 Each .24.0000

**

Location	Loc Qty	Loc Code
LG	24	
66875	8	
73253	1	
75021	4	
75022	10	
75023	1	

① mo 11-11-25

D2743

Manufactured No

D2743

Crossbolt Spacer

160 Each 127.0000

**

Location	Loc Qty	Loc Code
LG	69	
71839	5	
73403	64	
LG001	58	
67766	4	
68251	54	

BE11-12-06
B 76987
B 76141 18

D2739

Manufactured No

D2739

350 I Beam

160 Each 7.0000

**

Location	Loc Qty	Loc Code
LG	7	
72155	1	
76140	6	

BE11-12-05
B 76987

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 76667

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Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 18/11/2011

Required Date: 02/12/2011

Start Qty: 1.00

Required Qty: 1.00

D3490-3

Manufactured No

160 Each

86.0000 4 4

D3490-3

Cross Bolt Spacer

**

BE 11-12-06

Location	Loc Qty	Loc Code
LG	46	
73295	6	
76234	40	<i>14</i>
LG001	40	
74877	40	

D3490-1

Manufactured No

160 Each

74.0000 4 4

D3490-1

Cross Bolt Spacer

**

BE 11-12-06

Location	Loc Qty	Loc Code
LG	8	
67773	5	
71841	3	
LG001	66	
62450	2	
74875	64	<i>4</i>

ALS4-1032-225

Purchased No

220 Each

1,963.000 38 38

AI S4-1032-225

Insert

**

BR 11-12-22

Location	Loc Qty	Loc Code
ST281	1963	
108696	283	
110768	62	
118386	858	
118966 ✓	760	<i>38</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November-18-11 1:03:09 PM

Work Order ID: 76667

76667

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 18/11/2011

Required Date: 02/12/2011

Start Qty: 1.00

Required Qty: 1.00

D3793-3

Manufactured No

230

Each

26.0000

1

1

D3793-3

Wearshoe

**

BR 11-12-22

Location

Loc Qty

Loc Code

FP001

26

74528 ✓

9

74593

5

75043

12

AN8C35A

Purchased

No

230

Each

101.0000

1

1

AN8C35A

BOLT

**

BR 11-12-22

Location

Loc Qty

Loc Code

FP

66

115960

1

118286

65

ST345

34

117834 ✓

34

ST346

1

114442

0

115188

0

115960

1

D3793-1

Manufactured

No

230

Each

22.0000

1

1

D3793-1

Wearshoe

**

BR 11-12-22

Location

Loc Qty

Loc Code

FP001

12

75038

12

FP018

10

74591 ✓

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 6

Work Order ID: 76667

76667

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 18/11/2011

Required Date: 02/12/2011

Start Qty: 1.00

Required Qty: 1.00

D3488-041

Manufactured No

230

Each

24.0000

1

1

D3488-041

Blade Fitting Assembly, LH

**

BR 11-12-22

Location

Loc Qty

Loc Code

FG008

12

75056

12

FP

4

69903

4

FP007

1

61689

1

FP008

7

67788 ✓

1

71887

6

1

D3794-3

Manufactured No

230

Each

25.0000

1

1

D3794-3

Gasket

**

BR 11-12-22

Location

Loc Qty

Loc Code

FP002

25

74530

11

74596 ✓

14

1

AN6C44A

Purchased No

230

Each

115.0000

4

4

AN6C44A

BOLT

**

BR 11-12-22

Location

Loc Qty

Loc Code

FG

2

103964

2

ST343

113

118985 ✓

40

119125

30

119530

43

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November-18-11 1:03:10 PM

Page 7

Work Order ID: 76667

76667

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 18/11/2011

Required Date: 02/12/2011

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

230

Each

102.0000

1

1

MS21083C8

NUT

**

BR 11-12-22

Location

Loc Qty

Loc Code

FP-B

1

115884

1

ST293

1

118077

1

ST303

100

115884

0

118614 ✓

39

119309

11

119436

25

119638

25

D3536-25

Manufactured

No

230

Each

36.0000

1

1

D3536-25

Gasket

**

BR 11-12-22

Location

Loc Qty

Loc Code

FP012

36

74595

10

75039 ✓

26

D3631-1

Manufactured

No

230

Each

511.0000

8

8

D3631-1

Washer

**

BR 11-12-22

Location

Loc Qty

Loc Code

ST072

511

68062

11

75548 ✓

500

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November-18-11 1:03:10 PM

Page 8

Work Order ID: 76667

76667

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 18/11/2011

Required Date: 02/12/2011

Start Qty: 1.00

Required Qty: 1.00

D3791-1

Manufactured No

230

Each

33.0000

1

1

D3791-1

Wearplate

**

BL 11-12-22

Location

Loc Qty

Loc Code

FP002

16

75041

16

FP017

17

62239

2

74527

3

74598 ✓

12

AN960C10L

NAS1149C0332 ✓ Purchased

No

230

Each

0.0000

38

38

***AN960C10I ***

washer

119736.

**

38. BL 11-12-22

D2745

Manufactured No

230

Each

149.0000

8

8

D2745

Bushing

**

BL 11-12-22

Location

Loc Qty

Loc Code

FP

81

69529

1

74446 ✓

80

ST021

68

71835

68

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November-18-11 1:03:10 PM

Page 9

Work Order ID: 76667

76667

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 18/11/2011

Required Date: 02/12/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C5A

Purchased

No

230

Each

979.0000

34

34

AN3C5A

Bolt

**

BL 11-12-22

Location

Loc Qty

Loc Code

FP

119744

7

115835

7

ST350

972

116419

28

117343

17

117764

166

117872

2

118451

259

119127

500

34.

D3537-1

Manufactured

No

230

Each

72.0000

3

3

D3537-1

Wearpad

**

BL 11-12-22

Location

Loc Qty

Loc Code

FP002

74867

65

74436

48

74597

17

FP017

7

69817

5

70686

2

3.

NAS1149C0832R

Purchased

No

230

Each

333.0000

1

1

NAS1149C0832R

WASHER

**

BL 11-12-22

Location

Loc Qty

Loc Code

FP-B

5

114915

5

ST297

328

114915

328

1

November-18-11 1:03:10 PM

Shop Packet Print

Page 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November-18-11 1:03:10 PM

Page 10

Work Order ID: 76667

76667

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 18/11/2011

Required Date: 02/12/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C6A

Purchased

No

230

Each

260.0000

4

4

AN3C6A

BOLT

**

BR 11-12-22

Location

Loc Qty

Loc Code

FP

119744

1

4.

111982

1

ST350

100

119449

100

ST351

159

111982

2

116419

23

116549

2

116704

12

117619

10

117688

1

117872

5

118422

104

NAS1611-013

Purchased

No

230

Each

212.0000

8

8

NAS1611-013

O-RING

**

BR 11-12-22

Location

Loc Qty

Loc Code

FP

212

116582

5

117291

2

117887

53

119307

84

119438

18

119623

50

8

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November-18-11 1:03:10 PM

Work Order ID: 76667

76667

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 18/11/2011

Required Date: 02/12/2011

Start Qty: 1.00

Required Qty: 1.00

D3535-25

Manufactured No

230 Each

32.0000 1 1

D3535-25

Wearshoe

**

BR 11-12-22

Location Loc Qty Loc Code

FP001 22

74525 10

75040 12

FP018 10

62233 1

74592 9

D3794-1

Manufactured No

230 Each

43.0000 1 1

D3794-1

Gasket

**

BR 11-12-22

Location Loc Qty Loc Code

FP014 43

74529 3

74594 12

75042 28

MS21043-6

Purchased No

230 Each

457.0000 4 4

MS21043-6

NUT

**

BR 11-12-22

Location Loc Qty Loc Code

FG 20

103693 20

ST300 437

112314 227

117887 10

118384 200

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November-18-11 1:03:10 PM

Page 12

Work Order ID: 76667

76667

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 18/11/2011

Required Date: 02/12/2011

Start Qty: 1.00

Required Qty: 1.00

D3493-1

Manufactured No

250 Each

61.0000 2 2

**

[Handwritten signature]

D3493-1

Washer

Location

Loc Qty

Loc Code

ST062

61

70697

4

71846

27

76237

30

2

MS21083C8

Purchased No

250 Each

102.0000 2 2

**

[Handwritten signature]

MS21083C8

NUT

Location

Loc Qty

Loc Code

FP-B

1

115884

1

ST293

1

118077

1

ST303

100

115884

0

118614

39

119309

11

119436

25

119638

25

2

AN8C21A

Purchased No

250 Each

71.0000 2 2

**

[Handwritten signature]

AN8C21A

BOLT

Location

Loc Qty

Loc Code

ST343

71

118045

11

118758

30

119530

30

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November-18-11 1:03:10 PM

Page 13

Work Order ID: 76667

76667

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 18/11/2011

Required Date: 02/12/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1515H3L

Purchased

No

230

Each

163.0000

4

4

***NAS1515H3I ***

WASHER

**

BL 11-12-22

Location

Loc Qty

Loc Code

FG

40

102472

40

ST277

123

113362

19

118686

4

119438 ✓

100

Manufactured

No

250

Each

3.0000

1

1

D2741

D2741

Blade, 350 Skidtube

**

371856

Location

Loc Qty

Loc Code

ST466

3

70667

3

Manufactured

No

250

Each

46.0000

2

2

D3532-1

D3532-1

Spacer

**

11/12/22

Location

Loc Qty

Loc Code

ST065

46

73342

6

74880

40

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 76667 M.L.J
11/11/8

RELEASED

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3536-13/35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL); WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEC 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.07.16		
DART AEROSPACE USA, INC. PORT HADLOCK, WA		REV. F DRAWING NO. D2750 SHEET 1 OF 11 TITLE 350 SKIDTUBE ASSEMBLY SCALE NTS	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

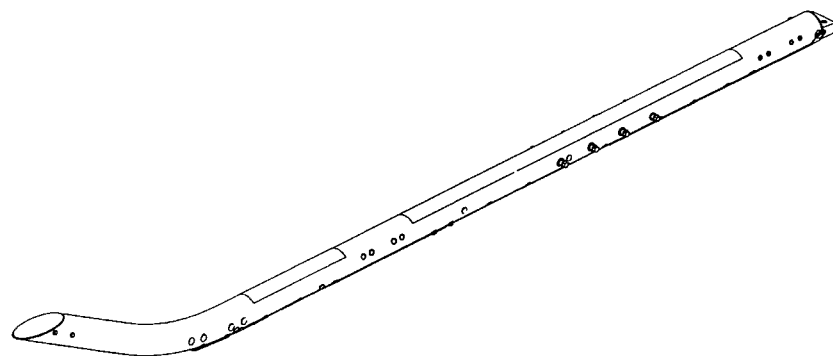
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

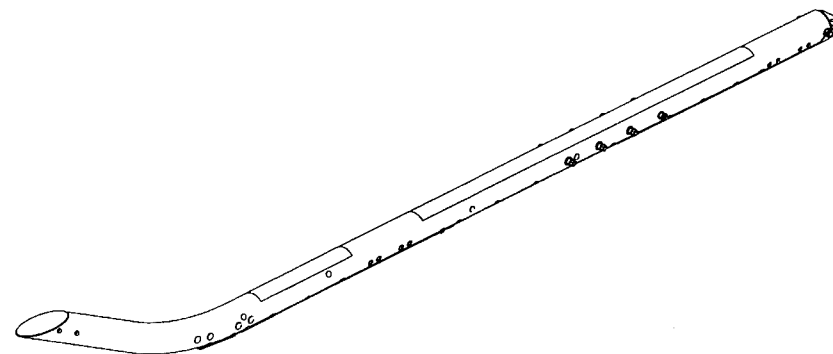
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

76667



D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

RELEASED
08-09-22/11

DESIGN	PC	DART AEROSPACE USA, INC.	
DRAWN	LA	PORT HADLOCK, WA	
CHECKED	A	DRAWING NO.	REV. F
MFG. APPR.	MA	D2750	SHEET 2 OF 11
APPROVED	ME	TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

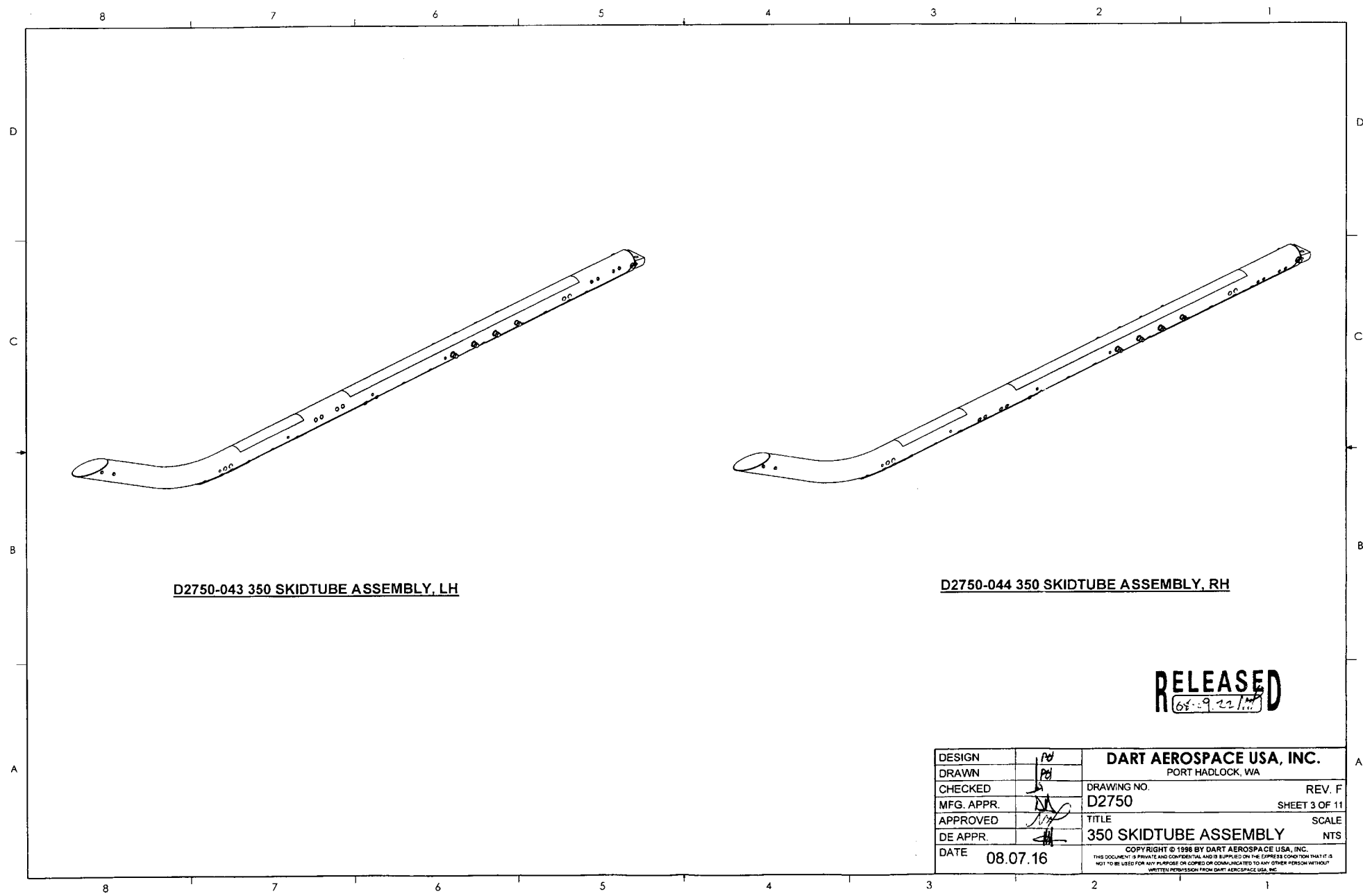
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

76667



D2750-043 350 SKIDTUBE ASSEMBLY, LH

D2750-044 350 SKIDTUBE ASSEMBLY, RH

RELEASED
68-9-22/111

DESIGN		DART AEROSPACE USA, INC. PORT HADLOCK, WA DRAWING NO. D2750 REV. F SHEET 3 OF 11 TITLE 350 SKIDTUBE ASSEMBLY SCALE NTS
DRAWN		
CHECKED		
MFG. APPR.		
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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

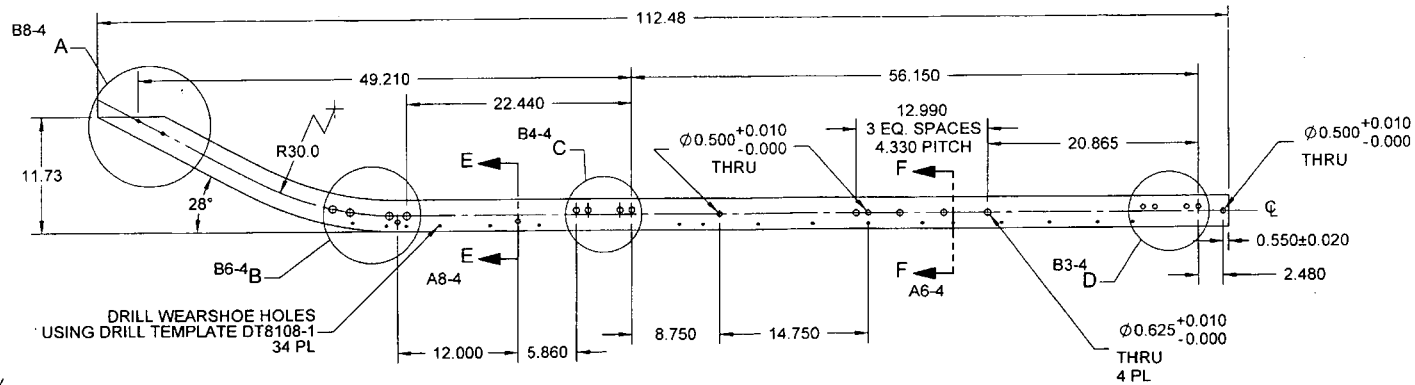
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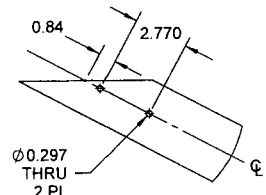
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

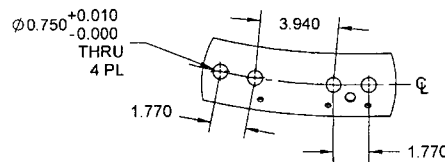
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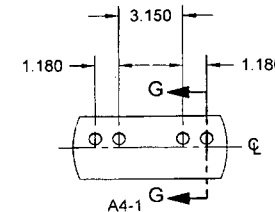
D2750-1 LH SKIDTUBE



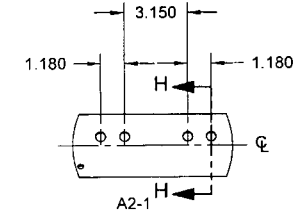
DETAIL A
SCALE 2X



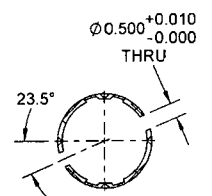
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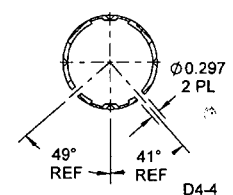
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SCALE 2X



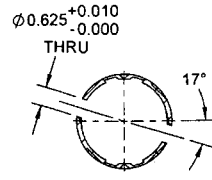
DETAIL D
SCALE 2X



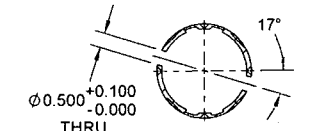
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL



SECTION H-H
SCALE 3X, 4 PL

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DESIGN	PA	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	PA		
CHECKED	PA	DRAWING NO. D2750	REV. F
MFG. APPR.			SHEET 4 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	
DATE	08.07.16	NTS	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

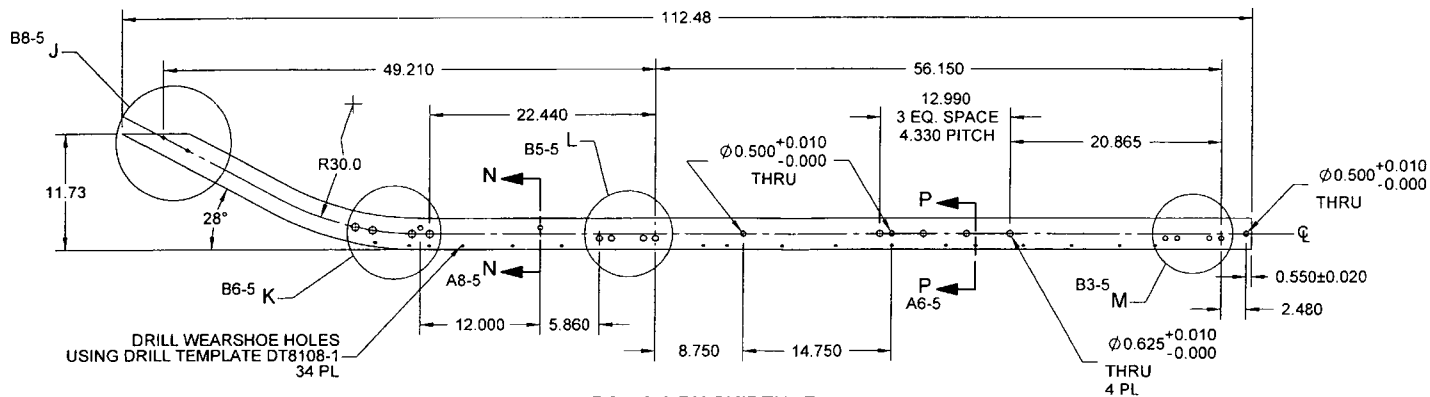
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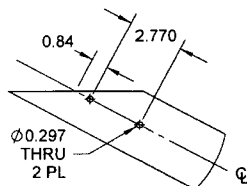
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

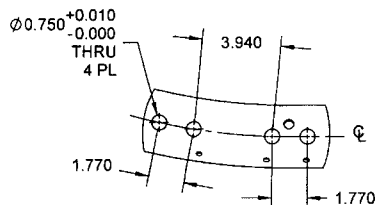
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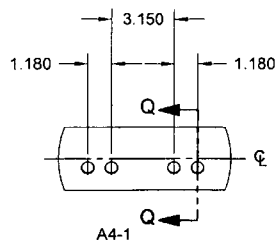
D2750-2 RH SKIDTUBE



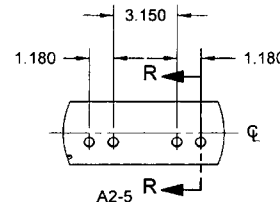
DETAIL J
SCALE 2X



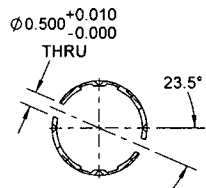
DETAIL K
SCALE 2X



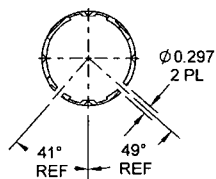
DETAIL L
SCALE 2X



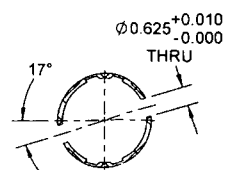
DETAIL M
SCALE 2X



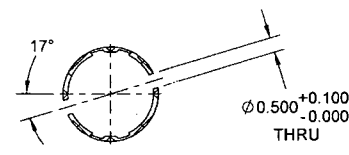
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL



SECTION R-R
SCALE 3X, 4 PL

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DESIGN	REV	DART AEROSPACE USA, INC.	
DRAWN	REV	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 5 OF 11
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

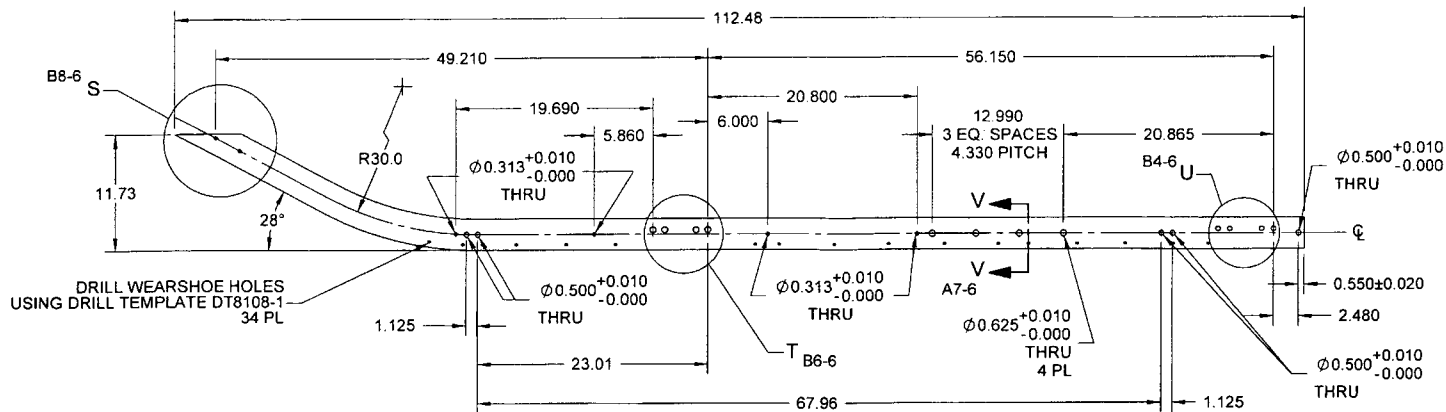
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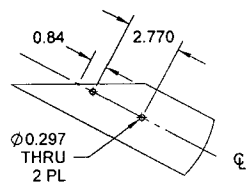
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

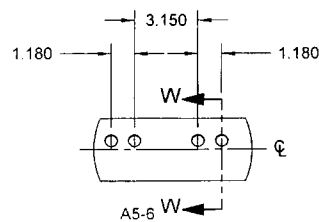
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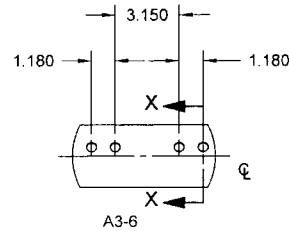
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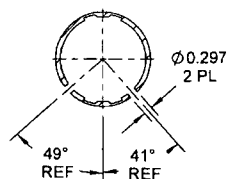
DETAIL S
SCALE 2X



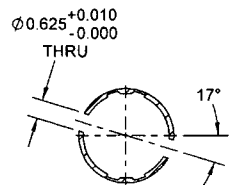
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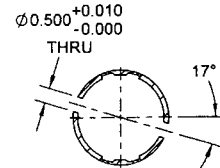
DETAIL U
SCALE 2X



SECTION V-V
SCALE 3X, 17 PL



SECTION W-W
SCALE 3X, 4 PL



SECTION X-X
SCALE 3X, 4 PL

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DESIGN		DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO. D2750	REV. F
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

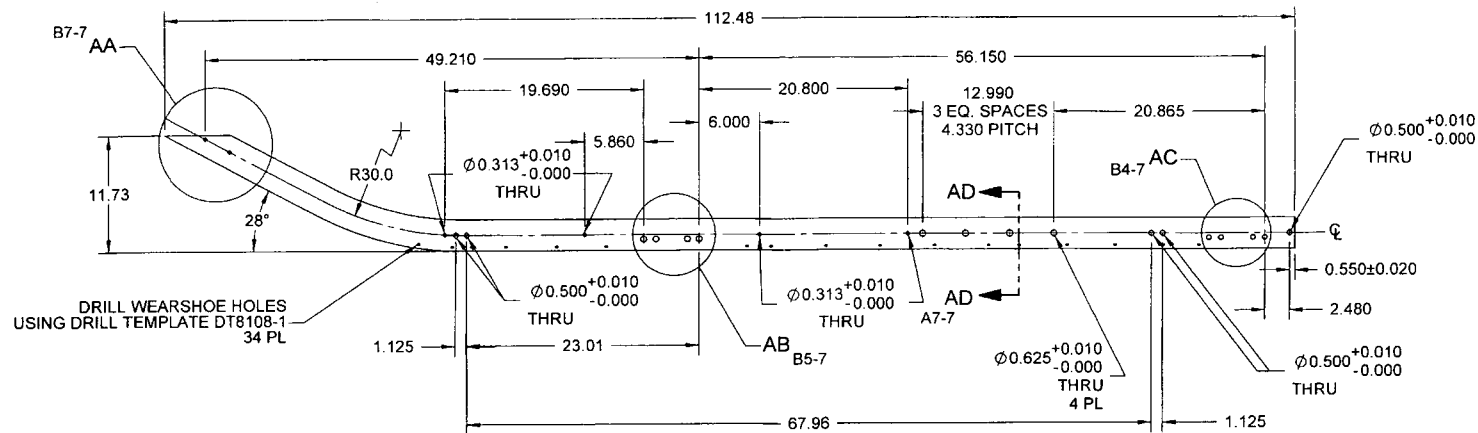
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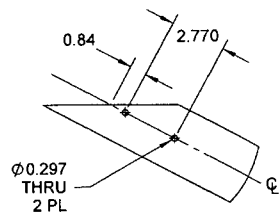
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

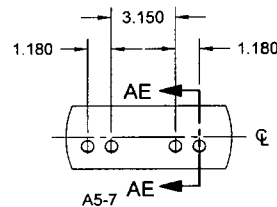
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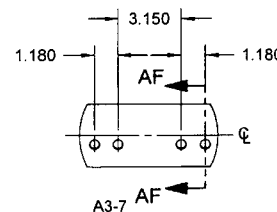
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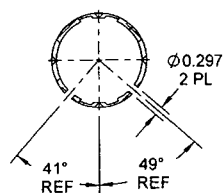
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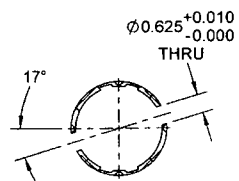
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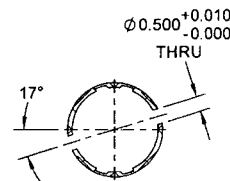
DETAIL AC
SCALE 2X



SECTION AD-AD
SCALE 3X, 17 PL



SECTION AE-AE
SCALE 3X, 4 PL



SECTION AF-AF
SCALE 3X, 4 PL

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DESIGN		DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 7 OF 11
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

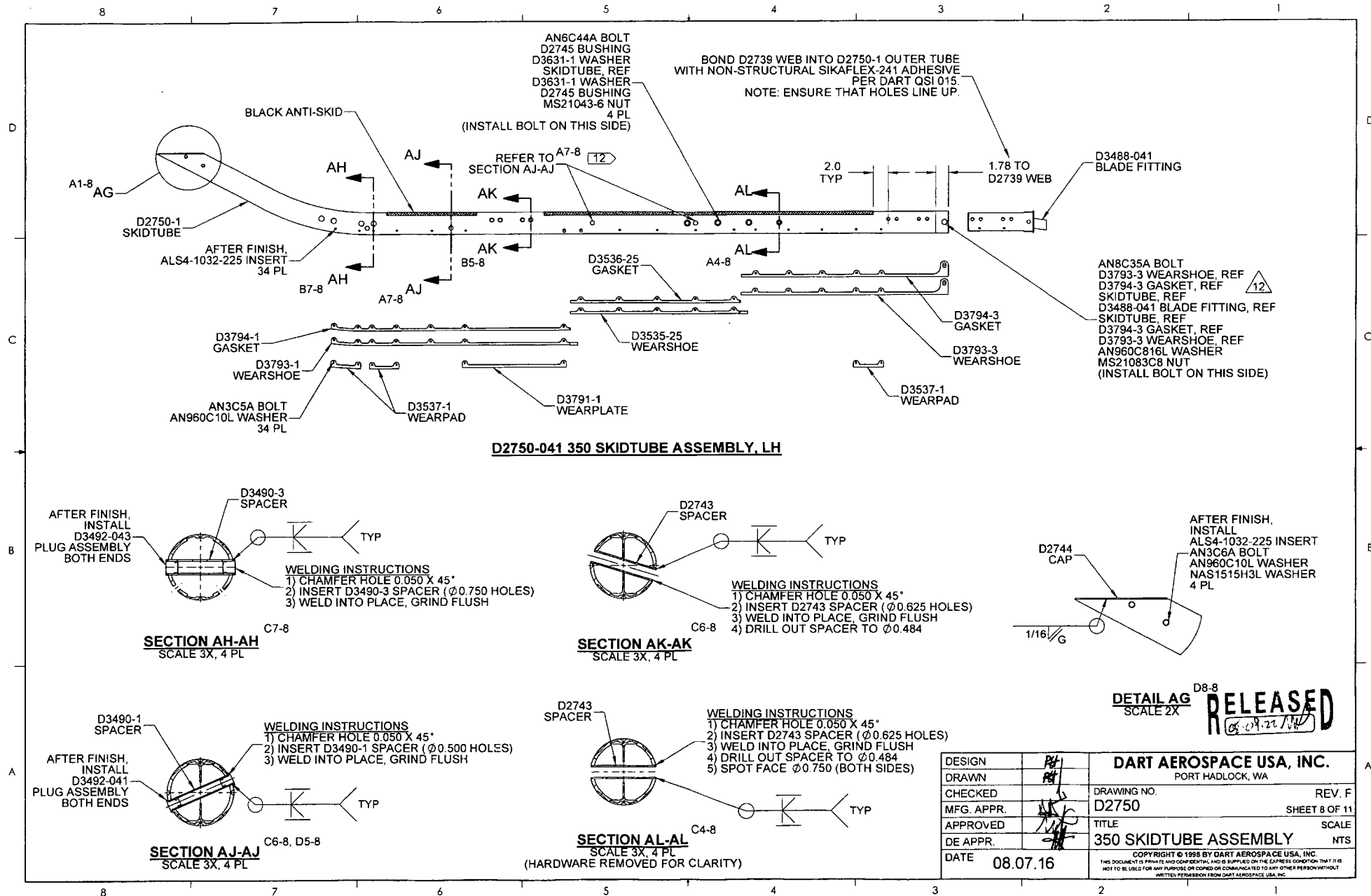
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

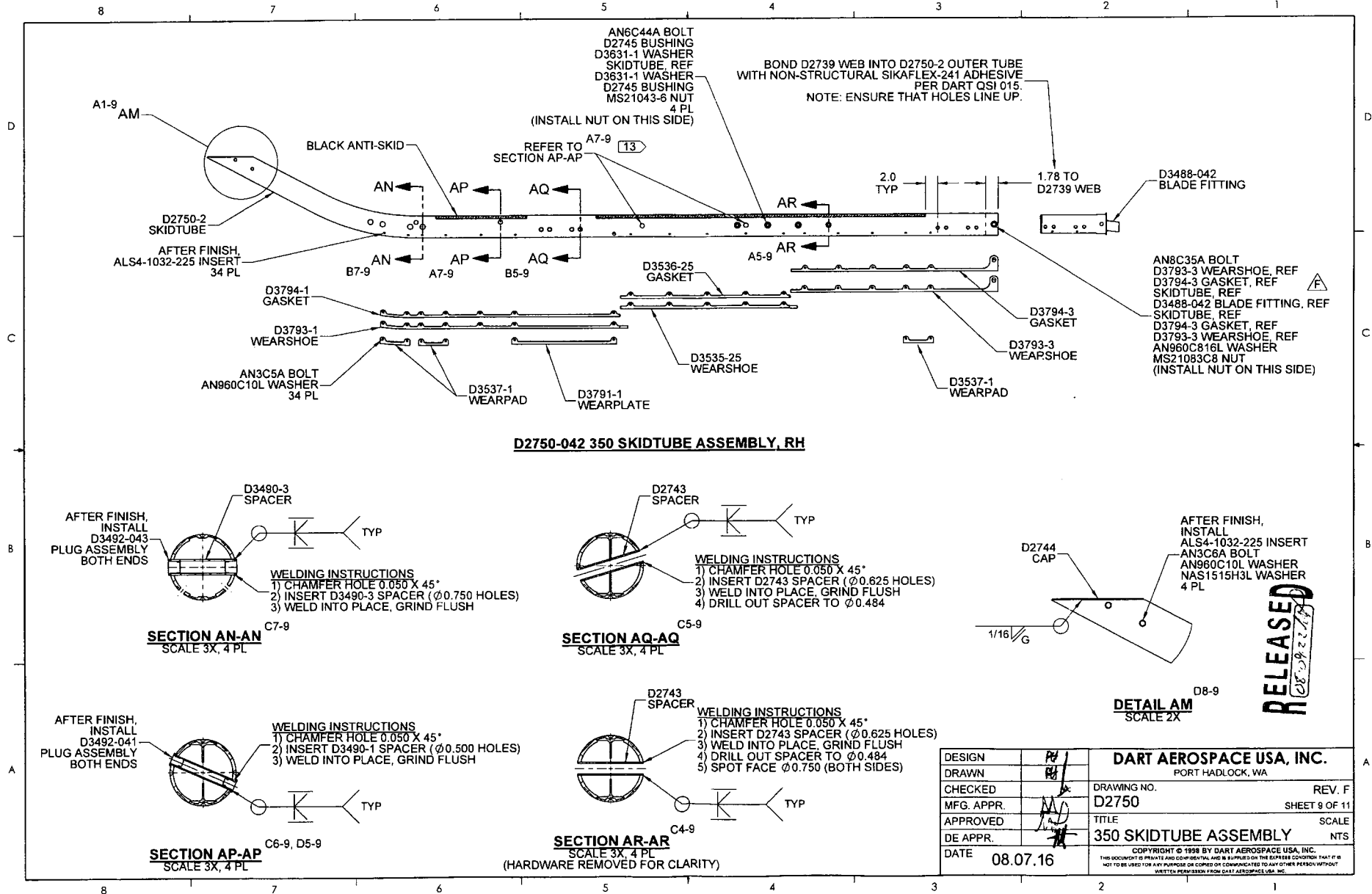
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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DESIGN	PH	DART AEROSPACE USA, INC.	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO.	REV. F
MFG. APPR.	MD	D2750	SHEET 9 OF 11
APPROVED	MD	TITLE	SCALE
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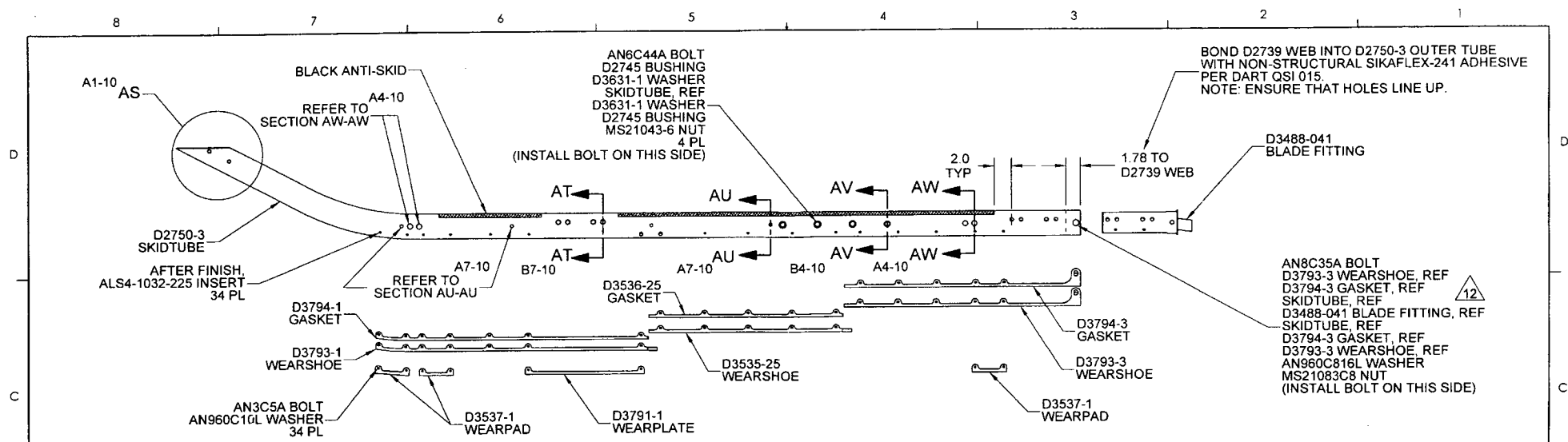
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
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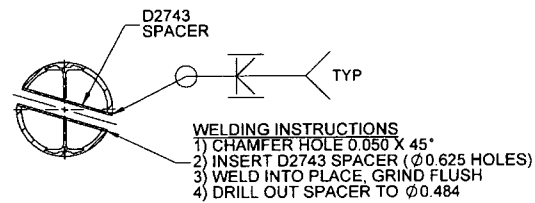
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

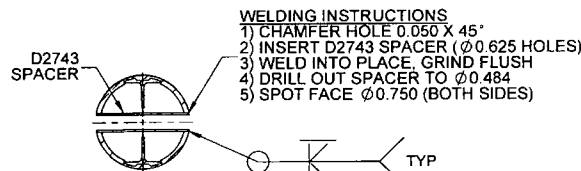
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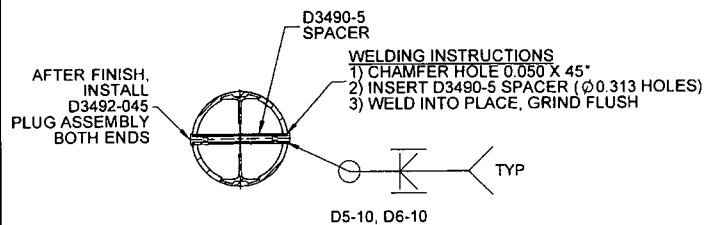
D2750-043 350 SKIDTUBE ASSEMBLY, LH



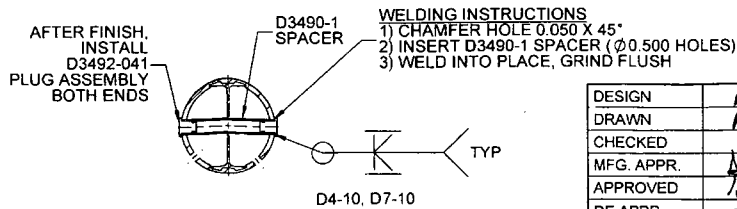
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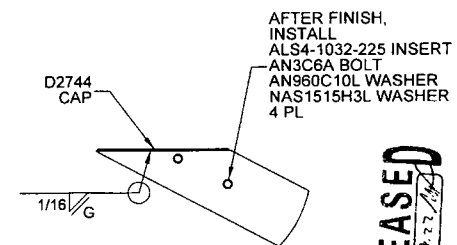
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SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)**



**SECTION AU-AU
SCALE 3X, 4 PL**



**SECTION AW-AW
SCALE 3X, 4 PL**



**DETAIL AS
SCALE 2X**

DESIGN	REV. F	DART AEROSPACE USA, INC.	
DRAWN	REV. F	PORT HADLOCK, WA	
CHECKED	REV. F	DRAWING NO.	REV. F
MFG. APPR.	REV. F	D2750	SHEET 10 OF 11
APPROVED	REV. F	TITLE	SCALE
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

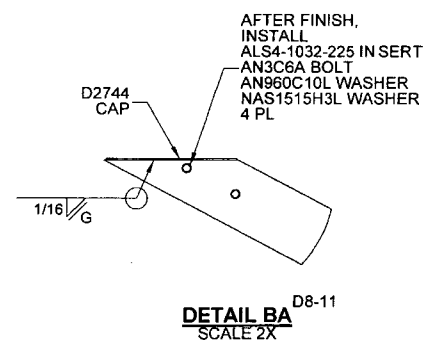
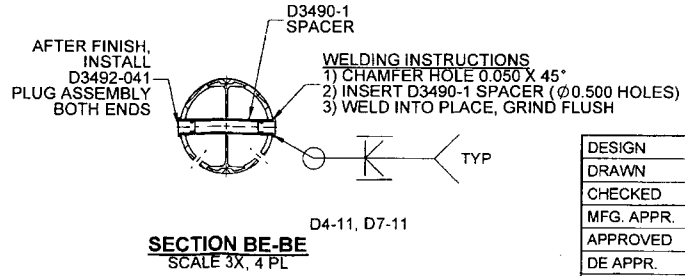
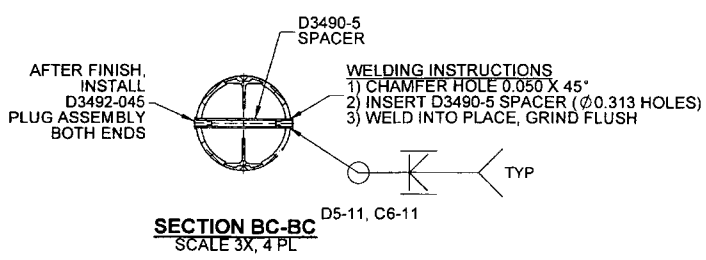
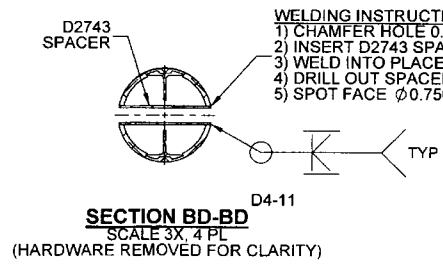
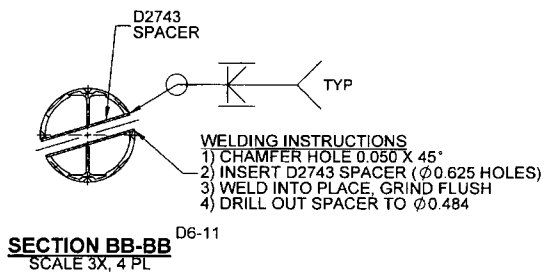
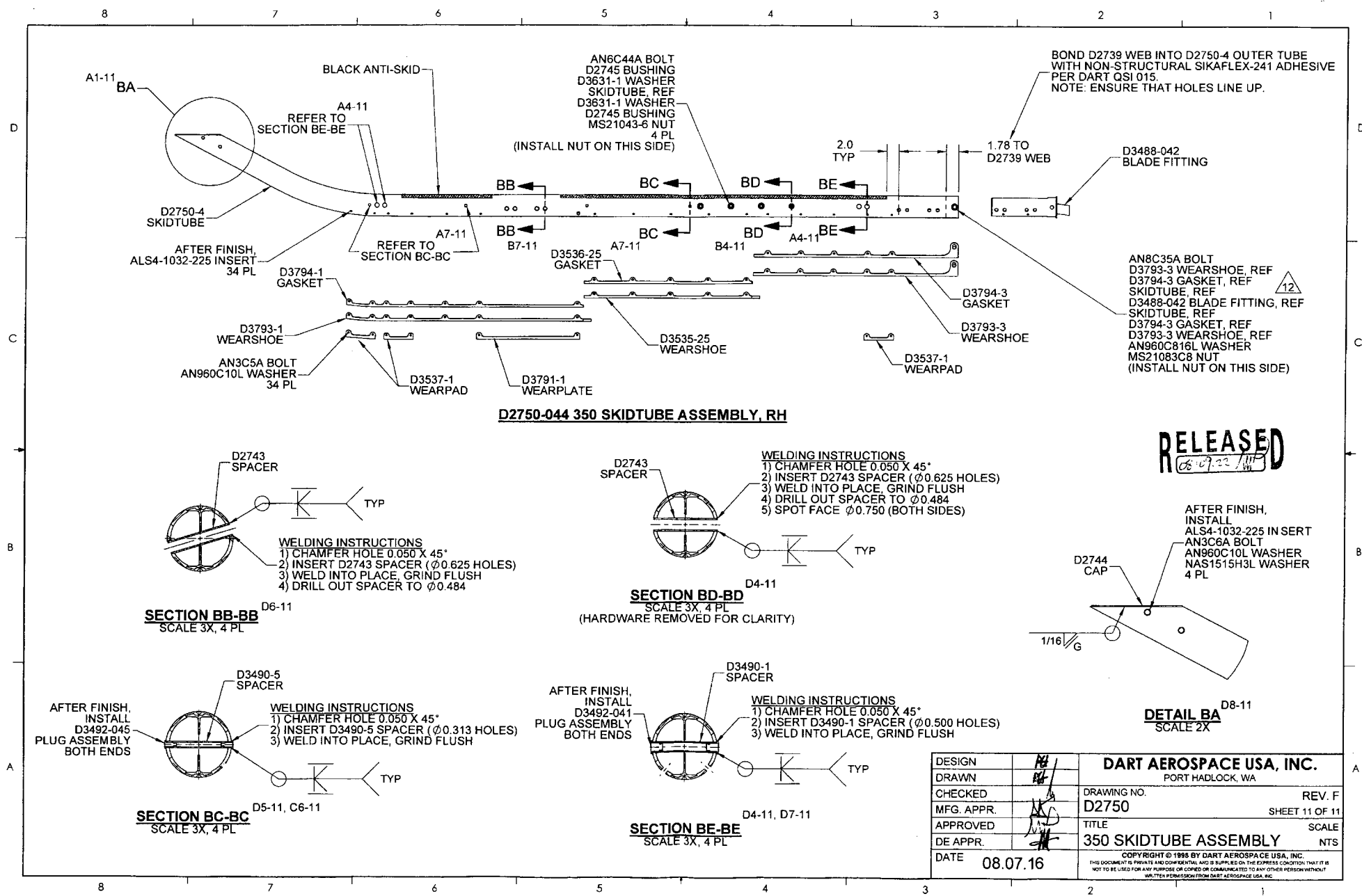
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

76667



DESIGN	76667	DART AEROSPACE USA, INC.	REV. F
DRAWN	AK	PORT HADLOCK, WA	
CHECKED	AK	DRAWING NO.	D2750
MFG. APPR.	AK		SHEET 11 OF 11
APPROVED	AK	TITLE	350 SKIDTUBE ASSEMBLY
DE APPR.	AK		SCALE NTS
DATE	08.07.16		

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 276

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliot
Job number: 75349
Part number: 350-636-011
Description: Skid tube
Welding Process: Tig[☒] Mig[]
Base material: Alum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier David Lund Date of Test Coupon 11.11.22
Welder Barclay Elliot Date of Test Coupon 11.11.22

The above named individual is qualified in accordance with AWS D17.1.2001 to weld